



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C250-200
Job Sheet 177406



Part No: C250-200

Job Qty: 3 ea

Part Name: Side Plate Housing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/10/18

Job Tracking No:

Due Date: 5/18/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C250-200 REV:4 IPP REV A 18.02.27 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		5/18/18	0.00	0.00	Start Up Machining		J.C.L.
110	Mori Seiki	3 pcs		5/18/18	0.00	3.00	MORI NV5000-1		J.C.L.
120	QC	3 pcs		5/18/18	0.00	0.00	QC2		J.C.L. 18-05-24
130	QC	3 pcs		5/18/18	0.00	0.00	QC8		7/21/18/05/24
150	Outsource	3 pcs		5/18/18			GRO002-VC		CT18-5-24
160	Packaging	3 pcs		5/18/18	0.00	0.00	Packaging2		AT 18/06/18
170	QC	3 pcs		5/18/18	0.00	0.00	QC6		ES
175	Small Fab	3 pcs		5/18/18	0.00	0.75	Small Fab-9		NA
180	QC	3 pcs		5/18/18	0.00	0.00	QC5		NA
185	Packaging	3 pcs		5/18/18	0.00	0.00	Packaging3		DAS
190	QC21-SA	3 Ea		5/18/18	0.00	0.00	QC21		21 18/06/18

Part Op 110 - 1-Machine as per folio FB FOLIO REV: _____ DWG REV: _____ 2-Debur

Descriptions: 120 - Engrave S/N Using Marktronic engraver. See note 1 for location.

150 - Issue P/O to ATG: P0039965 -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required

175 - Laser Etch, white as per dwg.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S2.250X13.500	6061-T6 Sheet 2.250" Thick x 13.500" Wide cut to size: 16.750"	4.1400 ft (1.38 ea)	90-Start up Operation	5066897

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S2.250X13.500	4	9	0

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Part Specifications

Specifications could not be found.



Container No: S073853



Part: C250-200

Job No: 177406

Serial No/Batch: S073853

Revision: 4

Inspector:

Plex 5/10/18 11:54 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	177406
Description: Side Plate Housing		Part Number:	C250-200
Inspection Dwg: C250	Rev: 3	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.186	± 0.005					
-2.088	± 0.005	2.083	✓		NV-5000-1	
3.700	± 0.005	3.695	✓			
2.560	± 0.005	2.555	✓			
9.310	± 0.005	9.305	✓			
8.600	± 0.005	8.595	✓			
6.656	± 0.005	6.651	✓			
10.72 UNF	2 B	O.K.	✓		GO NO-GO	
-1.368	± 0.005	-1.368	✓			
0.0	± 0.005	0	✓			
-.967	± 0.005	-.967	✓			
-.967	± 0.005	-.967	✓			
-0.967	± 0.005	-.967	✓			
.967	± 0.005	.967	✓			
0.0	± 0.005	0	✓			
-1.368	± 0.005	-1.368	✓			
0.0	± 0.005	0	✓			
1.368	± 0.005	1.368	✓			
.967	± 0.005	.967	✓			
-.967	± 0.005	-.967	✓			
.967	± 0.005	.967	✓			
-.967	± 0.005	-.967	✓			
.967	± 0.005	.967	✓			
.967	± 0.005	.967	✓			
1.368	± 0.005	1.368	✓			
0.0	± 0.005	0	✓			
Ø 0.250	± 0.005	0.250	✓		Caliper	5CL-09
.236	± 0.005	0.235	✓		NV-5000-1	
7.831	± 0.005	7.831	✓			

Measured by: J.C.L.	Checked by: [Signature]	QC Inspector:
Date: 18-05-17	Date: 18/05/24	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DART AEROSPACE LTD		Work Order: 177400
Description: Side Plate Housing		Part Number: C250-200
Inspection Dwg: C250	Rev: 3	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.986	± 0.005	1.986	✓			
7.831	± 0.005	7.831	✓			
1.625	± 0.005	0.625	✓			
1.460	± 0.005	1.461	✓			
0.9358	± 0.0005	0.9363	✓		Telescopic g.	
6.763	± 0.005	6.762	✓			
4.721	± 0.005	4.721	✓			
1.290	± 0.005	1.290	✓		Caliper	
1.145	± 0.005	1.140	✓			
0.6244	± 0.0004	0.6246	✓		P.G.	
0.081	± 0.005	0.081	✓			
5.980	± 0.005	5.980	✓			
0.758	± 0.005	0.755	✓		Caliper	
2.659	± 0.005	2.659	✓		W-Sort-1	
4.796	± 0.005	4.796	✓			
-1.793	± 0.005	-1.793	✓			
9.299	± 0.005	9.299	✓			
8.407	± 0.005	8.407	✓			
9.299	± 0.005	9.299	✓			
9.055	± 0.005	9.055	✓			
5.274	± 0.005	5.274	✓			
0.500	± 0.005	0.502	✓			
-0.817	± 0.005	-0.817	✓			
3.592	± 0.005	3.592	✓			
3.307	± 0.005	3.307	✓			
10.093	± 0.005	10.093	✓			
3.712	± 0.005	3.712	✓			
4.709	± 0.005	4.709	✓			
1.001	± 0.012	1.000	✓		Pin Gauge	
1.111	± 0.005	1.111	✓			
7.831	± 0.005	7.831	✓			
0.689	± 0.005	0.6874	✓		Pin G.	

Measured by: S.C.-L	Checked by: [Signature]	QC Inspector:
Date: 18-05-20	Date: 18/05/24	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

DART AEROSPACE LTD		Work Order: 177 406
Description: Side Plate Housing		Part Number: 0250-200
Inspection Dwg: 0250	Rev: 3	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.717	± 0.005	9.717	✓			
2.207	± 0.005	2.207	✓			
Ø 1.501	± 0.001	1.501	✓		T-6	
0.0	± 0.005	0.0	✓			
0.0	± 0.005	0.0	✓			
1.728	± 0.001	1.728	✓			
1.145	± 0.001	1.146	✓			
Ø 0.188	± 0.001	0.188	✓			
1.269	± 0.005	1.269	✓			
4.843	± 0.005	4.843	✓			
1.356	± 0.005	1.356	✓			
5.828	± 0.005	5.828	✓			
1.685	± 0.005	1.686	✓			
10.36	± 0.010	10.360	✓			
13.15	± 0.010	13.150	✓			
1/4-28 UNF	2B	OK	✓		60-110-6H	
Ø 0.50	± 0.010	0.510	✓			
3.750	± 0.005	3.750	✓			
2.500	± 0.005	2.502	✓			
1.080	± 0.004	1.061	✓			
1.188	± 0.004	1.188	✓			
0.230	± 0.003	0.228	✓			
Ø 2.813	± 0.001	2.812	✓			
2.020	± 0.003	2.021	✓			
0.095	± 0.005	0.090	✓			
Ø 1.07	± 0.010	1.028	✓			
Ø 1.28	± 0.010	1.278	✓			

Measured by: J.C. ✓	Checked by: [Signature]	QC Inspector:
Date: 18-05-20	Date: 18/05/24	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

TAG	X LOC	Y LOC	SIZE
A1	-2.088	3.700	$\varnothing .156$ THRU ALL $\sqcap \varnothing .316 \nabla 1.125$ $.02 \times 45^\circ$
A2	2.560	9.310	
A3	8.600	6.656	
B1	-1.368	-.000	
B2	-.967	-.967	
B3	-.967	.967	
B4	.000	-1.368	
B5	-.000	1.368	
B6	.967	-.967	
B7	.967	.967	
B8	1.368	.000	10-32 UNF - 28 THRU ALL
C1	.236	7.831	$\varnothing .250$ THRU ALL $.02 \times 45^\circ$ FAR SIDE $\sqcap \varnothing .625 \nabla 1.460$ $.02 \times 45^\circ$ NEAR SIDE
C2	1.986	7.831	
D1	6.763	4.721	$\varnothing .9363$ THRU ALL $.04 \times 45^\circ$ NEAR SIDE $\sqcap \varnothing 1.290 \nabla 1.145^{+.003}_{-.000}$
E1	.081	5.980	$\varnothing .6248$ THRU ALL $.03 \times 45^\circ$ NEAR SIDE $\varnothing .6244$
F1	-2.659	4.796	$\varnothing .750$ THRU ALL $2X .03 \times 45^\circ$
F2	-1.793	9.299	
F3	8.407	9.299	
F4	9.055	5.274	
G1	-.817	3.592	
G2	3.307	10.093	$\varnothing .500$ THRU ALL $2X .03 \times 45^\circ$
G3	3.712	4.709	
J1	1.111	7.831	$\varnothing 1.001$ THRU ALL $.03 \times 45^\circ$ NEAR SIDE $\sqcap \varnothing 1.165 \nabla 1.145^{+.003}_{-.000}$
K1	9.717	2.207	$\varnothing .689^{+.000}_{-.002}$ THRU ALL $2X .03 \times 45^\circ$ $\sqcap \varnothing .915 \nabla 1.155$
L1	.000	.000	$\varnothing 1.501^{+.000}_{-.001}$ THRU ALL $.03 \times 45^\circ$ NEAR SIDE $\sqcap \varnothing 1.728 \nabla 1.145^{+.003}_{-.000}$
M1	1.269	4.843	$\varnothing 188 \nabla 1.685$ $.02 \times 45^\circ$ NEAR SIDE
M2	1.356	5.828	

ASSY QTY	ASSY QTY	R/O	Part #	UNIT QTY	Description	Material	R/O INFORMATION OR SPECIFICATIONS
			C250-200	1	SIDE PLATE HORIZING	6061	2-18 x 13-1/4 x 16-1/2

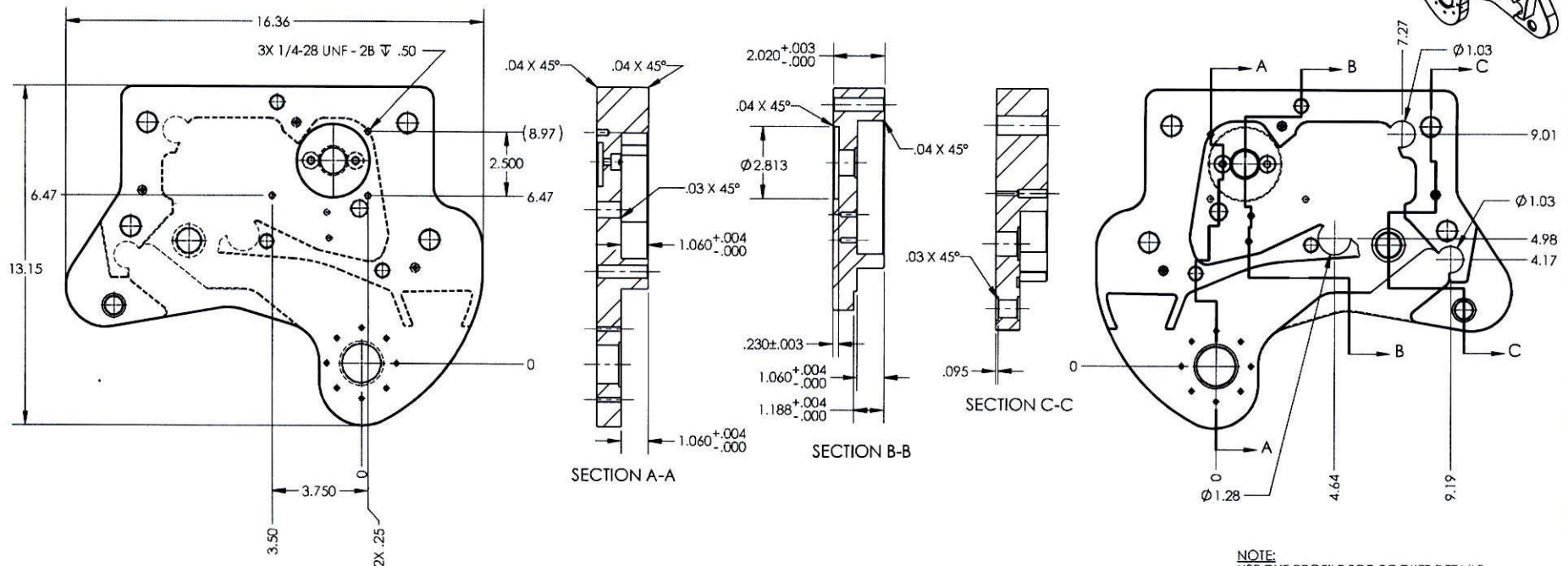
REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
		AS DRAWN BY APICAL.	6/11/2013	CFB		
1		CHD E1 HOLE TOLERANCE WAS Ø .027 + .000 - .001 IS Ø .6248 - .6244.	6/28/2013	CFB	JAG	
2		CHD E1 HOLE CHAMFER WAS .03 X 15° IS .03 X 45°.	8/20/2013	CFB	JAG	
3	14-0128	CHD TITLE BLOCK WAS RED BAKED DART. ADD MACHINE ENGRAVE NOTE: CHD DIMS WAS (13.151) & 13.15, WAS (16.361) IS 16.36, WAS (.350) IS .35, OLELETED DIM Ø .915. ADD DXF NOTE.	8/14/2014	DPD	RW	

NOTE:
① MACHINE ENGRAVE BATCH NUMBER.

	
TITLE SIDE PLATE HOUSING	
DWG NO. C250-200	REV 3
MAT'L 6061	DRAWN BY: APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS .XX ± .01 ANGLES 2.5° .X ± .1	APPROVED <i>D. Weir</i> REKT FINISH BLACK ANODIZE SPEC MIL-A-8625F, TYPE II CLASS II USED ON MODEL
1. BREAK ALL SHARP EDGES .015 ± .005 OR .0150 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:4	DATE 6/13/2011
SHEET 1 OF 2	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		CH D E1 HOLE TOLERANCE WAS $\phi .627 \pm .001$ E $\phi .6248-.6244$.	6/26/2013	CFJ
2		CH D E1 HOLE CHAMFER WAS $.01 \times 15^\circ$ B $.03 \times 45^\circ$	8/20/2013	CFJ
3	14-0128	CH D DIMS WAS (13.15) B 13.15, WAS (16.36) B 16.36, WAS (3.50) B 3.50, DELETED DIM $\phi .915$ ADDED DXF NOTE	8/14/2014	DPD
				RW



NOTE:
USE DXF PROFILE FOR POCKET DETAILS.

DART AEROSPACE	
TITLE SIDE PLATE HOUSING	
DWG NO. C250-200	REV 3
MAT'L 6061	DRAWN BY: APICAL
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>D. West</i>
.XXX ± .005 FRACTIONS & 1/8	TEXT
.XX ± .01 ANGLES & 5°	FINISH
.X ± .1	BLACK ANODIZE
1. BREAK ALL SHARP EDGES .015 X 45°	SPEC MIL-A-8625F, TYPE II, CLASS II
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:4	DATE 8/13/2011
SHEET 2 OF 2	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039965**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039965
PO Date: 5/23/18
Due Date: 5/31/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments: CT.

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	173867	RBE350A93-3500-00-1	Body -Issue P/O to Groupe Altech: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant as per Dwg RBE350A93-3500-00-1 Rev. 3A -Certificate of Conformity is required	Firmed	5/31/18	12 pcs	0 pcs	12 pcs	\$15.5263157/pcs	\$186.32
3	177272	RBW6305G11331-3G-13	Socket -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	5/31/18	1 pcs	0 pcs	1 pcs	\$95.526315/pcs	\$95.53
4	177405	C250-100	Side Plate Cover -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	5/31/18	3 pcs	0 pcs	3 pcs	\$64.026315/pcs	\$192.08
5	177406	C250-200	Side Plate Housing -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	5/31/18	3 pcs	0 pcs	3 pcs	\$76.52631/pcs	\$229.58
Grand Total:										\$703.50



Certificat de Conformité / Certificate of Compliance

(009663-3)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

009663 - 3

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
01-Jun-2018		Aman		PO039965				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3500-00-1 Rev.	RBE350A93-3500-00-1 01-ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT	ANODIZE CH	12	12	0	0	0
4	C250-100 Rev.	C250-100 01-ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	3	3	0	0	0
5	C250-200 Rev.	C250-200 01-ANO-BLACK [ANODIZE BLACK] TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	3	3	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.